

Work Order ID 154332

Thursday, December 08, 2016 11:34:26 AM

154332

Page 1

Item ID: D3885-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Float Web
Start Date: 12/8/2016 Start Qty: 8.00 ***R*** **DEC 08 2016** **DAS 13 9-59**
Required Date: 12/22/2016 Req'd Qty: 8.00 ***R*** Cust Item ID:
Reference: Customer:

Approvals: Process Plan: **DAS 13 9-59** Date: **DEC 08 2016** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	C								

108

0.00

108

Purchasing

Purchasing

Memo

Purchasing

Issue P/O: **34575**

Supplier: WEJAY.

Machine as per Dwg D3885

Conformity sheet required

0.00

DEC 08 2016**DAS 13 9-59**

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

10x Sp7-01-10

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NS1

NS2

g

Customer:

NR1

NIDQ

NIDQ

(15) 17.01.20 9
9-89

(X10) ~~4~~ 2017/02/01
BEB

DAS
03
9-89

⑩ 17-2-7

Quality Control

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Item ID: D3885-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Float Web
Start Date: 12/8/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 12/22/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

17-2-7

17/2/8

FEB 07 2017

Picklist Print

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Work Order ID: 154332

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Parent Item: D3885-3

D3885-3

Parent Item Name: Float Web

Start Date: 12/8/2016

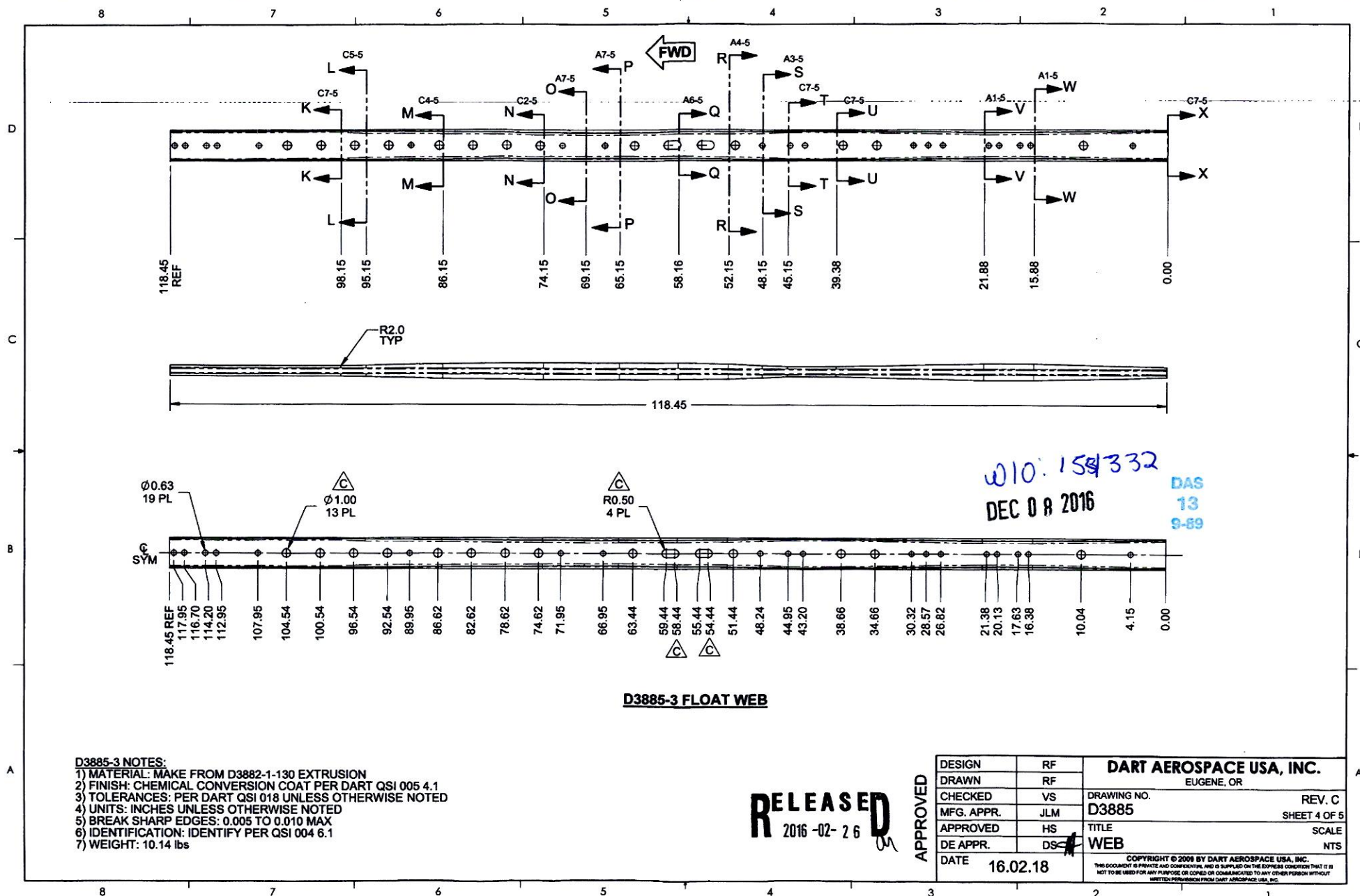
Required Date: 12/22/2016

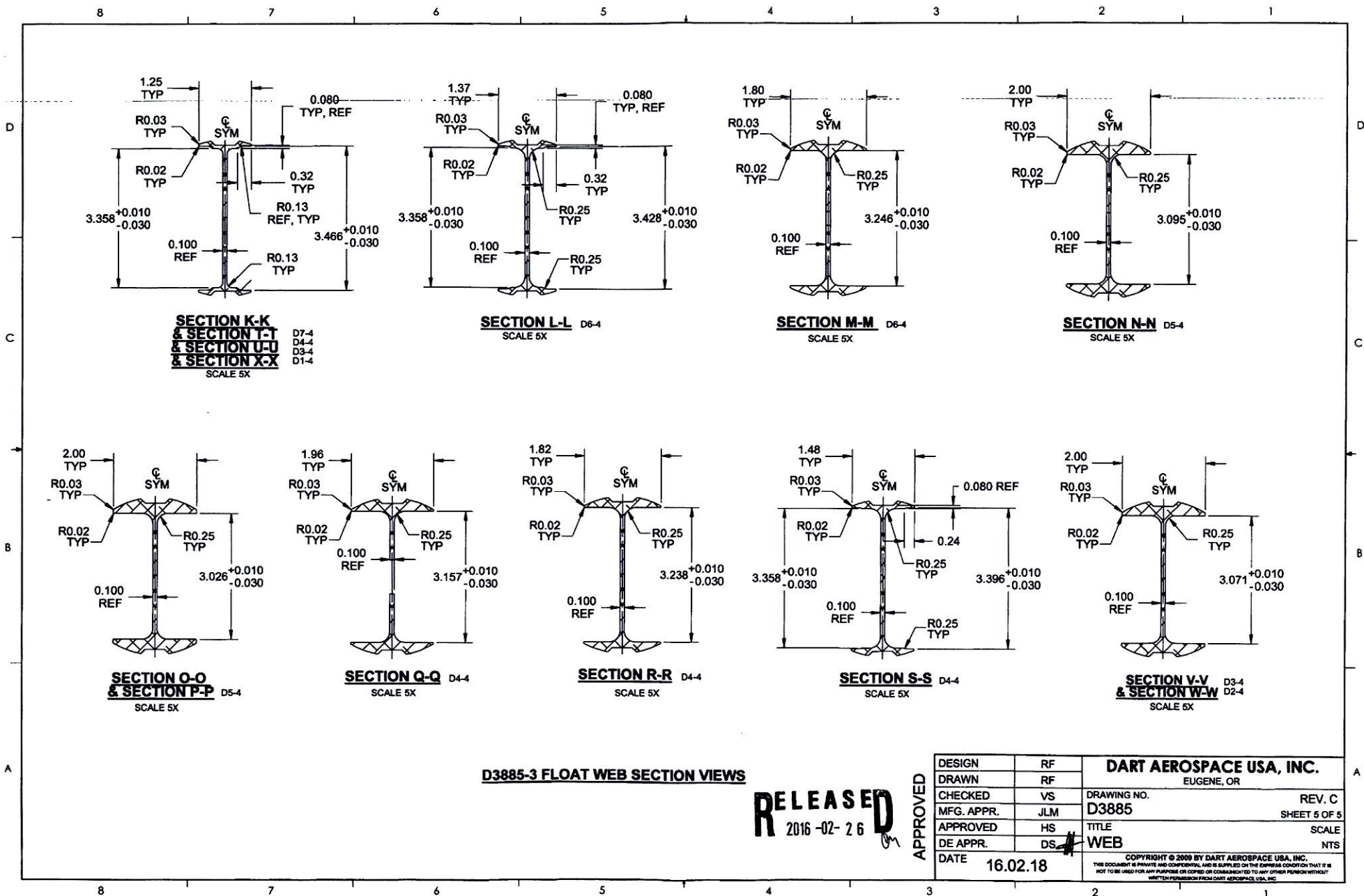
Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 *D3882-1-130* Extrusion "I" Beam		Manufactured	No			110	Each	44.0000	1	<i>K10</i>		DEC 08 2016	DAS 13 9-89
				<u>Location</u> WEJAY				<u>Loc Qty</u> 44					
					151997			44					
D3885-3P *D3885-3P* Float Web		Purchased	No				Each	0.0000		<i>10</i>			<i>10x SP17-01-10.</i>
										**			





12/8/2016

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace

DATE: Jan. 9, 2017

P.O.# PO34575

WEJAY JOB# 38355

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-3P 'Float Web' B154332	10	Machined supplied extrusions complete per drawing req'ts	D3885 sheets 4-5 / rev. C

Note: 1) Material supplied by Dart Aerospace.
2) Inspection Reports attached.

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38355

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 34575

PART No. D3885-3P

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. C

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: Paul Rousen
Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
--

DATE: Dec. 13, 2016

WMP
03

INSTRUCTIONS, COMMENTS **FIRST ARTICLE** / IN PROCESS / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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1	Hole, Diameter .63"	19 places	+0.008/-0.001		.634 typ.	1	Accepted
2a	Hole, Diameter 1.00"	13 places	+0.010/-0.001		1.002 typ.	1	Accepted
2b	Slot, Rad 0.50"	2 x 2 places	+/- .03		.501 typ.	1	Accepted
3	4.15"		+/- .03		4.151	1	Accepted
4	10.04"		+/- .03		10.039	1	Accepted
5	16.38"		+/- .03		16.380	1	Accepted
6	17.63"		+/- .03		17.628	1	Accepted
7	20.13"		+/- .03		20.126	1	Accepted
8	21.38"		+/- .03		21.375	1	Accepted
9	26.82"		+/- .03		26.811	1	Accepted
10	28.57"		+/- .03		28.559	1	Accepted
11	30.32"		+/- .03		30.308	1	Accepted
12	34.66"		+/- .03		34.65	1	Accepted
13	38.66"		+/- .03		38.652	1	Accepted
14	43.20"		+/- .03		43.185	1	Accepted
15	44.95"		+/- .03		44.937	1	Accepted
16	48.24"		+/- .03		48.23	1	Accepted
17	51.44"		+/- .03		51.429	1	Accepted
18a	54.44"		+/- .03		54.433	1	Accepted
18b	55.44"		+/- .03		55.433	1	Accepted
19a	58.44"		+/- .03		58.433	1	Accepted
19b	59.44"		+/- .03		59.434	1	Accepted
20	63.44"		+/- .03		63.432	1	Accepted
21	66.95"		+/- .03		66.946	1	Accepted
22	71.95"		+/- .03		71.946	1	Accepted
23	74.62"		+/- .03		74.62	1	Accepted
24	78.62"		+/- .03		78.6282.621	1	Accepted
25	82.62"		+/- .03		82.621	1	Accepted
26	86.62"		+/- .03		86.622	1	Accepted
27	89.95"		+/- .03		89.948	1	Accepted
28	92.54"		+/- .03		92.538	1	Accepted
29	96.54"		+/- .03		96.538	1	Accepted
30	100.54"		+/- .03		100.537	1	Accepted
31	104.54"		+/- .03		104.537	1	Accepted
32	107.95"		+/- .03		107.945	1	Accepted

INSPECTION / TEST REPORT

JOB No. 38355

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O PO 34575

PART No.D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. C

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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33	112.95"		+/- .03		112.944	1	Accepted
34	114.20"		+/- .03		114.193	1	Accepted
35	116.70"		+/- .03		116.693	1	Accepted
36	117.95"		+/- .03		117.943	1	Accepted
37	1.25" TYP	Section K-K,T-T,U-U,X-X			1.260	1	Accepted
38	R.03" TYP				.03	1	Accepted
39	R.02" TYP				.02	1	Accepted
40	3.358"		+0.010/-0.030		3.355	1	Accepted
41	R.13" TYP				.130	1	Accepted
42	.32" TYP				.320	1	Accepted
43	3.466"		+0.010/-0.030		3.462	1	Accepted
44	R.13" TYP				.130	1	Accepted
45	.080 TYP,REF				.080	1	Accepted
46	1.37" TYP	Section L-L			1.364	1	Accepted
47	R.03" TYP				.03	1	Accepted
48	R.02" TYP				.02	1	Accepted
49	3.358"		+0.010/-0.030		3.353	1	Accepted
50	R.25" TYP				.250	1	Accepted
51	.32" TYP				.315	1	Accepted
52	R.25" TYP				.250	1	Accepted
53	3.428"		+0.010/-0.030		3.425	1	Accepted
54	1.80" TYP	Section M-M			1.793	1	Accepted
55	R.03" TYP				.03	1	Accepted
56	R.02" TYP				.02	1	Accepted
57	3.246"		+0.010/-0.030		3.243	1	Accepted
58	R.25" TYP				.250	1	Accepted
59	2.00" TYP	Section N-N			1.985	1	Accepted
60	R.03" TYP				.03	1	Accepted
61	R.02" TYP				.02	1	Accepted
62	3.095"		+0.010/-0.030		3.090	1	Accepted
63	R.25" TYP				.250	1	Accepted
64	2.00" TYP	Section O-O,P-P			1.988	1	Accepted
65	R.03" TYP				.03	1	Accepted
66	R.02" TYP				.02	1	Accepted
67	3.026"		+0.010/-0.030		3.018- 3.035	1	Accepted
68	R.25" TYP				.250	1	Accepted
69	1.96"	Section Q-Q			1.958	1	Accepted
70	R.03" TYP				.03	1	Accepted
71	R.02" TYP				.02	1	Accepted
72	3.157		+0.010/-0.030		3.152	1	Accepted
73	R.25" TYP				.250	1	Accepted
74	1.82"	Section R-R			1.810	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38355	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O PO 34575							
PART No.D3885-3				DESCRIPTION: Float Web			
DWG No. D3885 - sheets 4-5				REV. C		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

75	R.03" TYP				.03	1	Accepted
76	R.02" TYP				.02	1	Accepted
77	3.238"	Section R-R Cont'd	+ .010/- .030		3.234	1	Accepted
78	R.25" TYP				.250	1	Accepted
79	1.48"	Section S-S			1.470	1	Accepted
80	R.03" TYP				.03	1	Accepted
81	R.02" TYP				.02	1	Accepted
82	3.358		+ .010/- .030		3.350	1	Accepted
83	R.25" TYP				.250	1	Accepted
84	3.396"		+ .010/- .030		3.395	1	Accepted
85	R.25" TYP				.250	1	Accepted
86	2.00"	Section V-V, W-W			1.988	1	Accepted
87	R.03" TYP				.03	1	Accepted
88	R.02" TYP				.02	1	Accepted
89	3.071"		+ .010/- .030		3.066	1	Accepted
90	R.25" TYP				.250	1	Accepted
91	118.45	O.A. length	± .030		118.443	1	Accepted